



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3914-041
Job Sheet 167247



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/17	0.00	0.00	Start Up Large Fab2		DG 2017-11-23
100	Large Fab	1 pcs		11/16/17	0.00	6.67	Large Fab 1		CP
110	QC	1 pcs		11/16/17	0.00	0.00	QC9		PD 12-11-23
120	QC	1 pcs		11/16/17	0.00	0.00	QC5		PD 17-11-23
130	Powdercoat	1 pcs		11/16/17	0.00	0.40	Powdercoat4		BR 17-12-11
135	QC	1 pcs		11/16/17	0.00	0.00	QC3		11/12/17
140	HandFinish	1 pcs		11/17/17	0.00	0.80	HandFinish3		11/12/17
150	QC	1 pcs		11/17/17	0.00	0.00	QC3		17-12-1424
160	Packaging	1 pcs		11/17/17	0.00	0.00	Packaging3		11/12/17
170	QC21-SA	1 Ea		11/17/17	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***
130 - *** mask sides of hinge prior to powdercoat***
140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 135418 START: 9:25 O.V.T: 320° FINISH: 9:55.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5005842	2	16	0	0
	D3914-1 2004269	2	6	0	0
	D3914-7 5004433	2	10	0	0
	D4016-3 5010799	3	19	0	0
	D4018-5 5007318	9	45	0	0
	D4020-5 5001022	1	8	0	0
	D4021-3 5007083	1	7	0	0
	D4035-043 5004890	2	0	0	0
140-HandFinish	D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																					
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																			
Description Work		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																			
 S012917 Long Basket Lid Assembly (350)		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																					
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Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Environment ☐</td><td style="width:50%;">No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐			Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr><td style="width:33%;">☐ Crushing</td><td style="width:33%;">☐ Countersink</td><td style="width:33%;">☐ Off-set</td></tr> <tr><td>☐ Heat Treat</td><td>☐ Cut Too Short</td><td>☐ Mislabeled</td></tr> <tr><td>☐ Wave/Twist in Tube</td><td>☐ Instructions Incomplete/Unclear</td><td>☐ Fit/Function</td></tr> <tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Misaligned/off center</td></tr> </table>		☐ Crushing	☐ Countersink	☐ Off-set	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Marks/Chatter
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